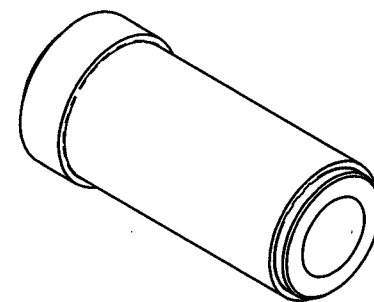
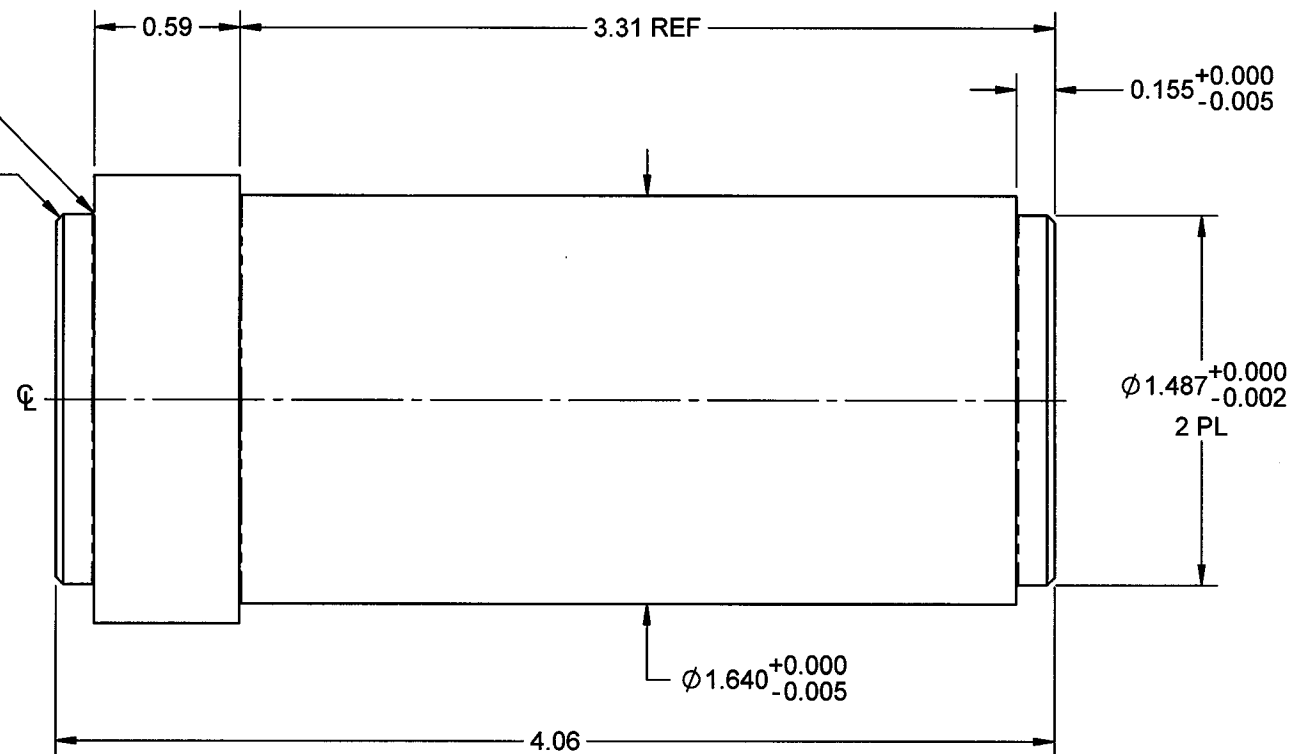


**RBE117-15004W6-1 DRIFT**

8 9 10

R0.008 MAX  
3 PL

0.03 X 45.0° CMF  
2 PL



**NOTES:**

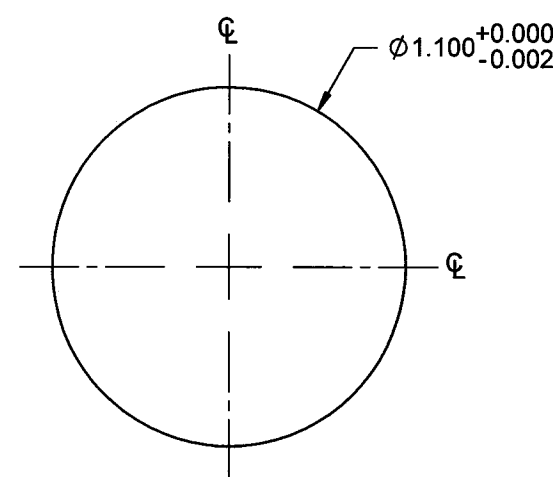
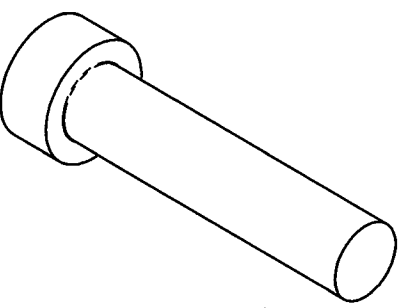
- 1) MATERIAL: O1 TOOL STEEL PER ASTM A681
- 2) HEAT TREAT: 48-52 RC
- 3) FINISH: ZINC PLATE PER ASTM B633 SC 2 TYPE 2 (BLACK CHROMATE CONVERSION COATING)
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010
- 7) IDENTIFICATION: N/A
- 8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG
- 9) PART IS SYMMETRIC ABOUT CENTERLINES
- 10) DIMENSIONAL LIMITS APPLY AFTER PLATING

**RELEASED**  
2020 SEP 04

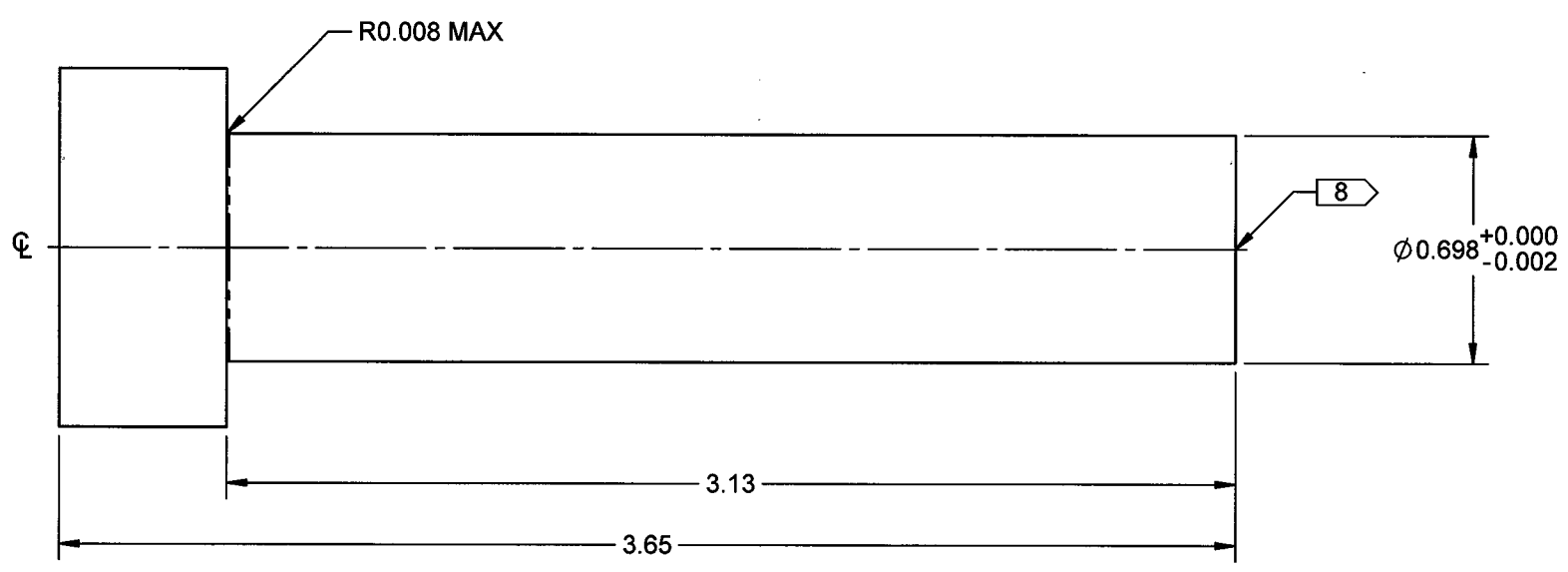
DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	KPT	TOOL PART #	REV. C
MFG. APPR.	FK	<b>RBE117-15004W6</b>	SHEET 2 OF 14
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE <b>9/1/2020</b>		<b>PUSH OUT / PRESS IN TOOL</b>	NTS
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8 7 6 5 4 3 2 1



RBE117-15004W6-3 THRUST PIECE 1

9 10 11

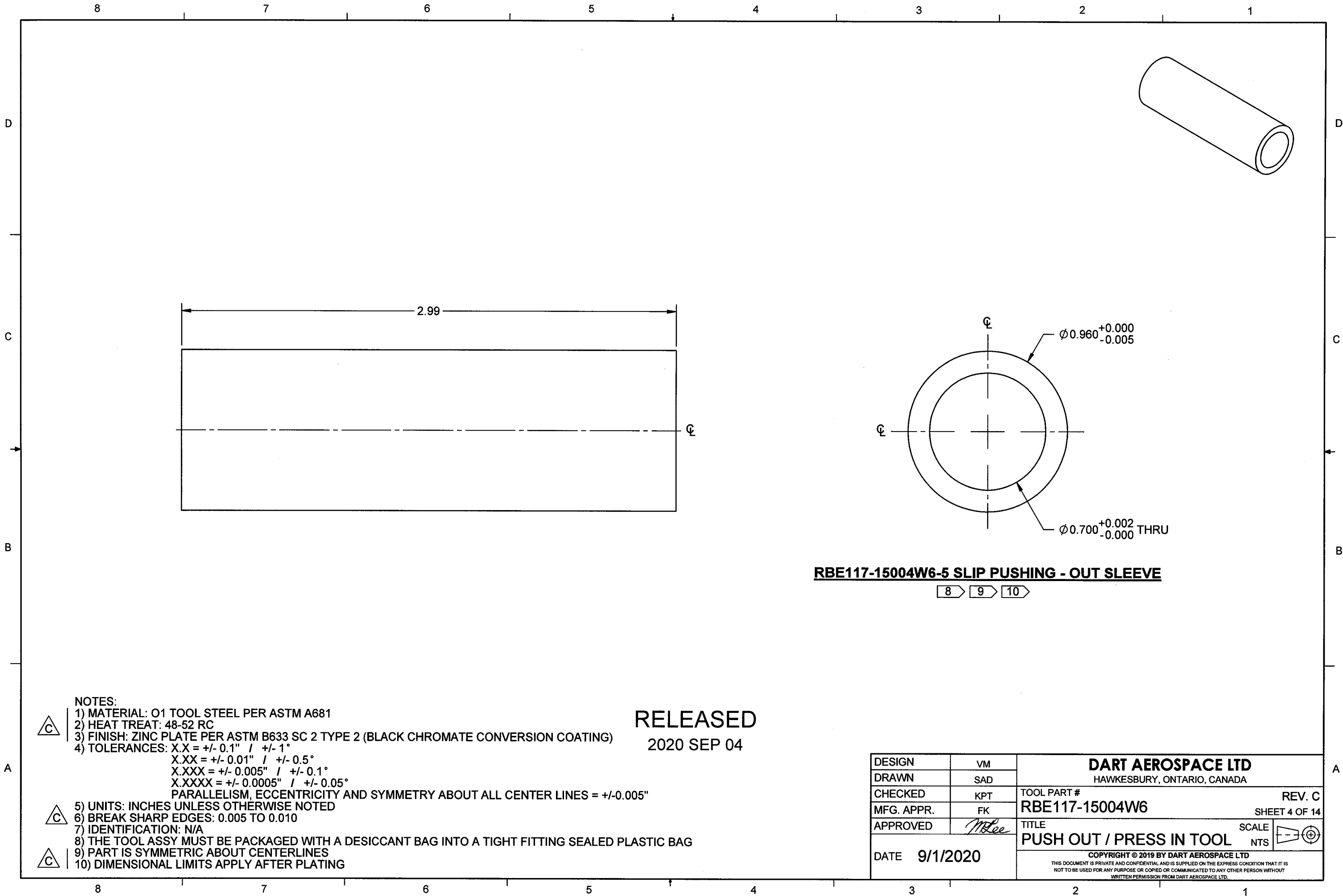


NOTES:

- 1) MATERIAL: O1 TOOL STEEL PER ASTM A681
- 2) HEAT TREAT: 48-52 RC
- 3) FINISH: ZINC PLATE PER ASTM B633 SC 2 TYPE 2 (BLACK CHROMATE CONVERSION COATING)
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG
- 10) PART IS SYMMETRIC ABOUT CENTERLINES
- 11) DIMENSIONAL LIMITS APPLY AFTER PLATING

RELEASED  
2020 SEP 04

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	KPT	TOOL PART #	REV. C
MFG. APPR.	FK	RBE117-15004W6	SHEET 3 OF 14
APPROVED	<i>MLee</i>	TITLE	SCALE
DATE 9/1/2020		PUSH OUT / PRESS IN TOOL	NTS
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**RBE117-15004W6-5 SLIP PUSHING - OUT SLEEVE**

8 9 10

NOTES:

- 1) MATERIAL: O1 TOOL STEEL PER ASTM A681  
2) HEAT TREAT: 48-52 RC  
3) FINISH: ZINC PLATE PER ASTM B633 SC 2 TYPE 2 (BLACK CHROMATE CONVERSION COATING)  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) BREAK SHARP EDGES: 0.005 TO 0.010  
7) IDENTIFICATION: N/A  
8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG  
9) PART IS SYMMETRIC ABOUT CENTERLINES  
10) DIMENSIONAL LIMITS APPLY AFTER PLATING

RELEASED  
2020 SEP 04

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	KPT	TOOL PART #	REV. C
MFG. APPR.	FK	RBE117-15004W6	SHEET 4 OF 14
APPROVED	<i>MLee</i>	TITLE	SCALE
DATE 9/1/2020		PUSH OUT / PRESS IN TOOL	NTS
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8

7

6

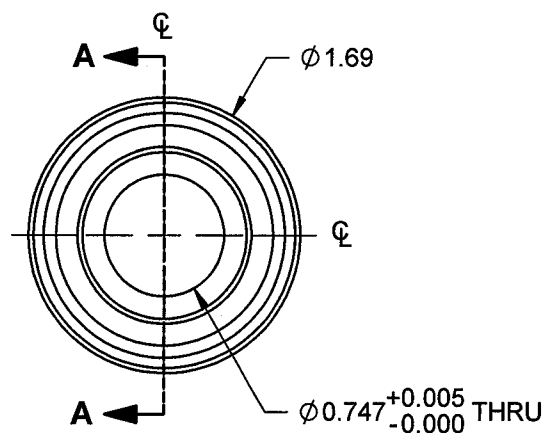
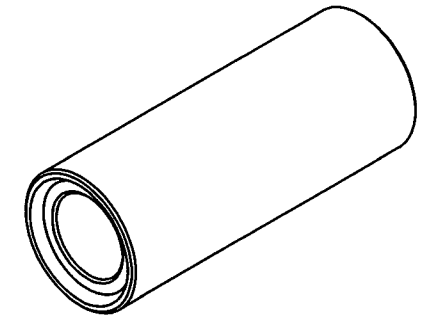
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4

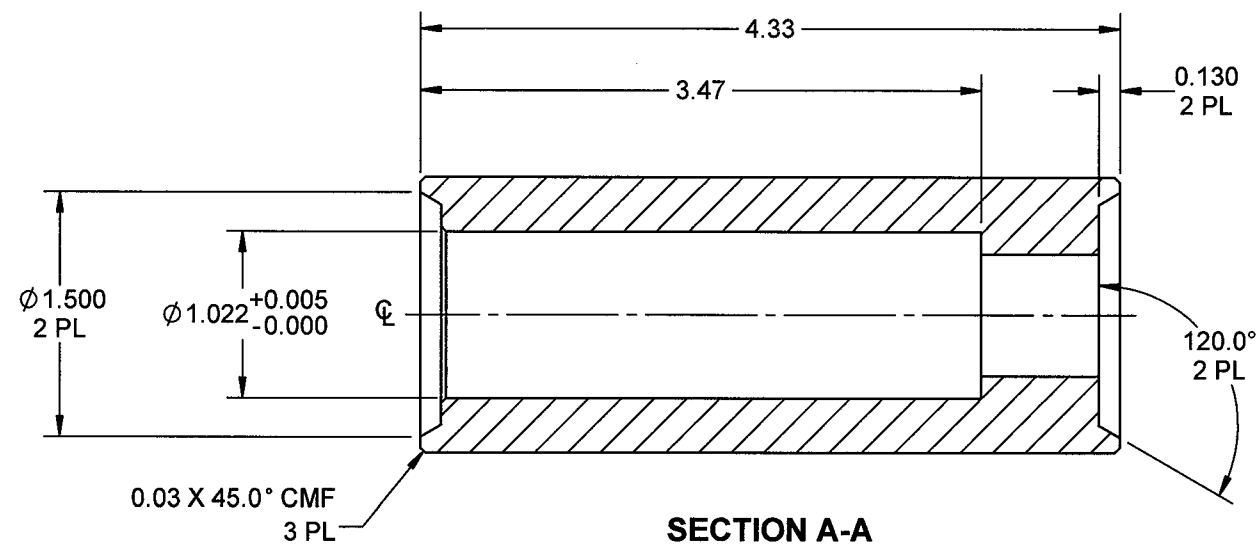
3

2

1

**RBE117-15004W6-7 SUPPORT 1**

8 9 10

**SECTION A-A****NOTES:**

- 1) MATERIAL: O1 TOOL STEEL PER ASTM A681  
2) HEAT TREAT: 48-52 RC  
3) FINISH: ZINC PLATE PER ASTM B633 SC 2 TYPE 2 (BLACK CHROMATE CONVERSION COATING)  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

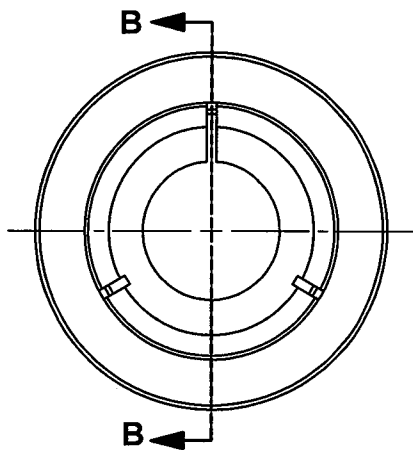
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) BREAK SHARP EDGES: 0.005 TO 0.010  
7) IDENTIFICATION: N/A  
8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG  
9) PART IS SYMMETRIC ABOUT CENTERLINES  
10) DIMENSIONAL LIMITS APPLY AFTER PLATING

**RELEASED**

2020 SEP 04

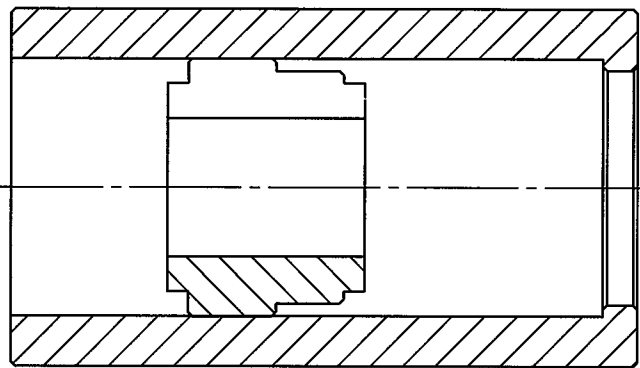
DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. C
MFG. APPR.	FK	<b>RBE117-15004W6</b>	SHEET 5 OF 14
APPROVED	<i>MLee</i>	TITLE	SCALE
DATE <b>9/1/2020</b>		<b>PUSH OUT / PRESS IN TOOL</b>	NTS
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ITEM #	QTY	P/N	DESCRIPTION
-11	1	RBE117-15004W6-11	SUPPORT 2
-13	1	RBE117-15004W6-13	CENTERING PIECE

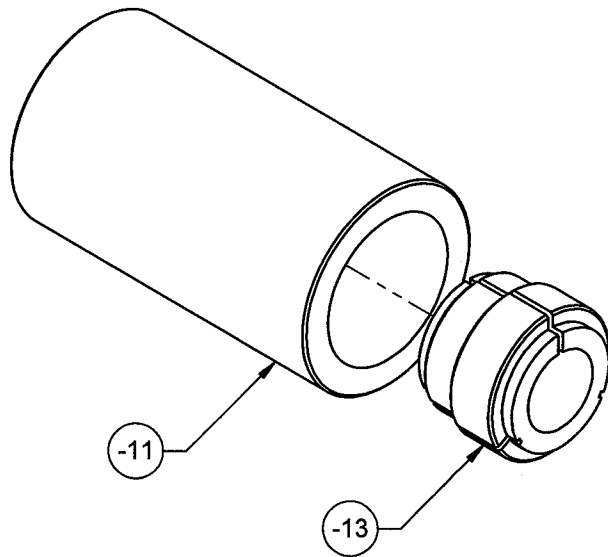


**RBE117-15004W6-9 CENTERING PIECE ASSEMBLY**

9



**SECTION B-B**



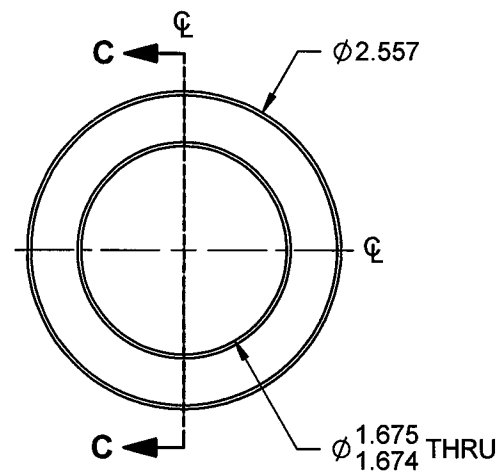
NOTES:

- 1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) BREAK SHARP EDGES: N/A  
7) IDENTIFICATION: N/A  
8) ASSEMBLE AS SHOWN  
9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

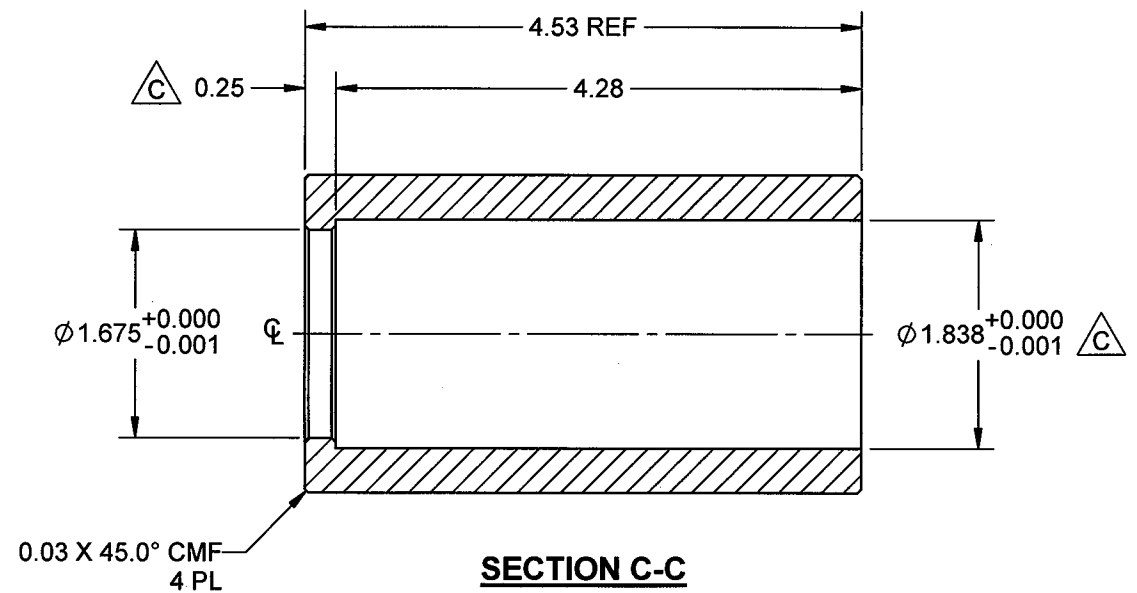
RELEASED  
2020 SEP 04

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	KPT	TOOL PART #	REV. C
MFG. APPR.	FK	RBE117-15004W6	SHEET 6 OF 14
APPROVED	<i>MLee</i>	TITLE	SCALE
DATE 9/1/2020		PUSH OUT / PRESS IN TOOL	NTS
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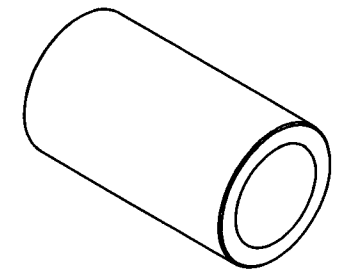


**RBE117-15004W6-11 SUPPORT 2**

8 9



**SECTION C-C**



**NOTES:**

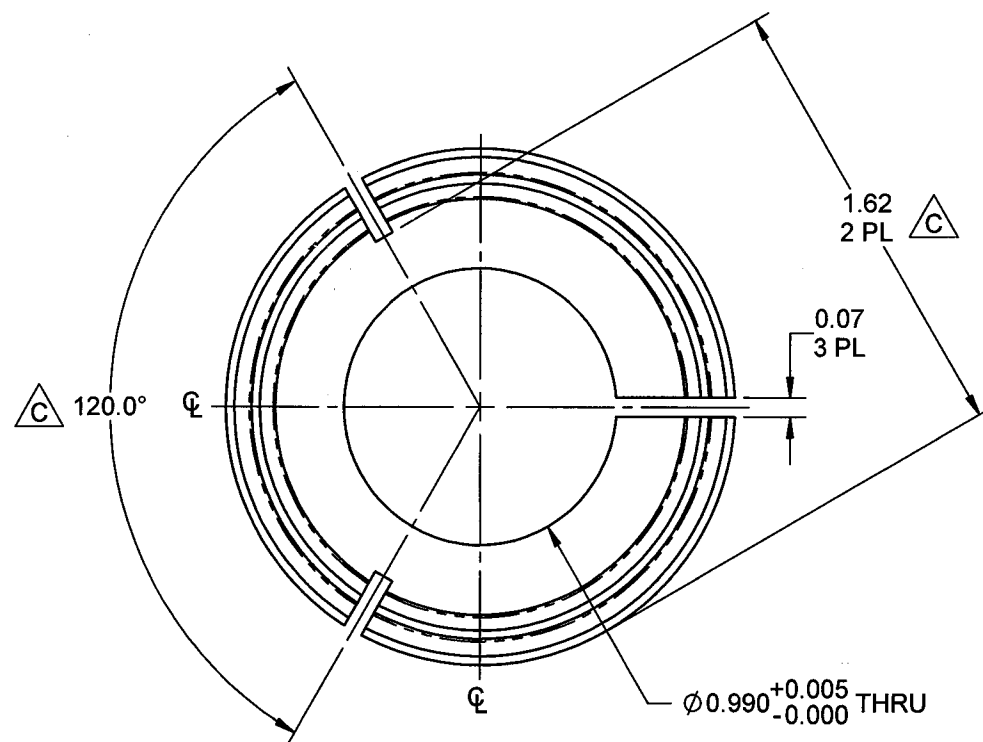
- 1) MATERIAL: O1 TOOL STEEL PER ASTM A681
- 2) HEAT TREAT: 48-52 RC
- 3) FINISH: ZINC PLATE PER ASTM B633 SC 2 TYPE 2 (BLACK CHROMATE CONVERSION COATING)
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010
- 7) IDENTIFICATION: N/A
- 8) PART IS SYMMETRIC ABOUT CENTERLINES
- 9) DIMENSIONAL LIMITS APPLY AFTER PLATING

**RELEASED**

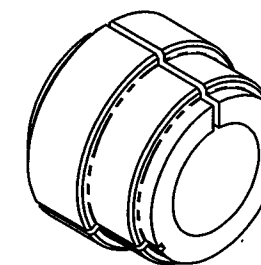
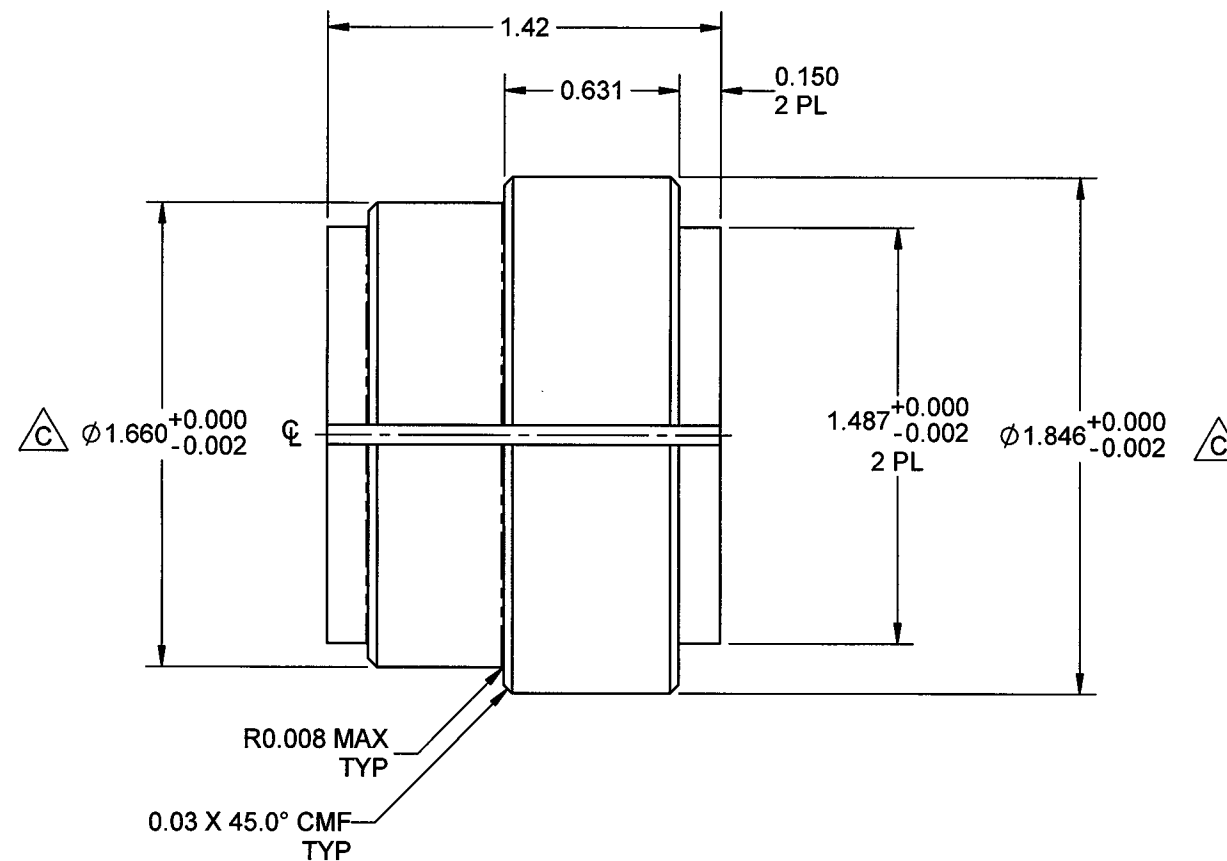
2020 SEP 04

DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. C
MFG. APPR.	FK	<b>RBE117-15004W6</b>	SHEET 7 OF 14
APPROVED	<i>MLee</i>	TITLE	SCALE
DATE <b>9/1/2020</b>		<b>PUSH OUT / PRESS IN TOOL</b>	NTS
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**RBE117-15004W6-13 CENTERING PIECE**

8



**NOTES:**

1) MATERIAL: WHITE DELRIN/ACETAL PLASTIC PER ASTM D6100

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005 TO 0.010

7) IDENTIFICATION: N/A

8) PART IS SYMMETRIC ABOUT CENTERLINES



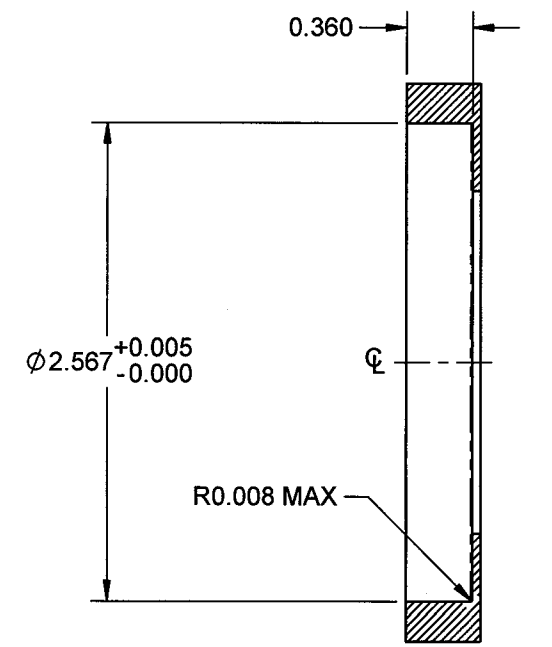
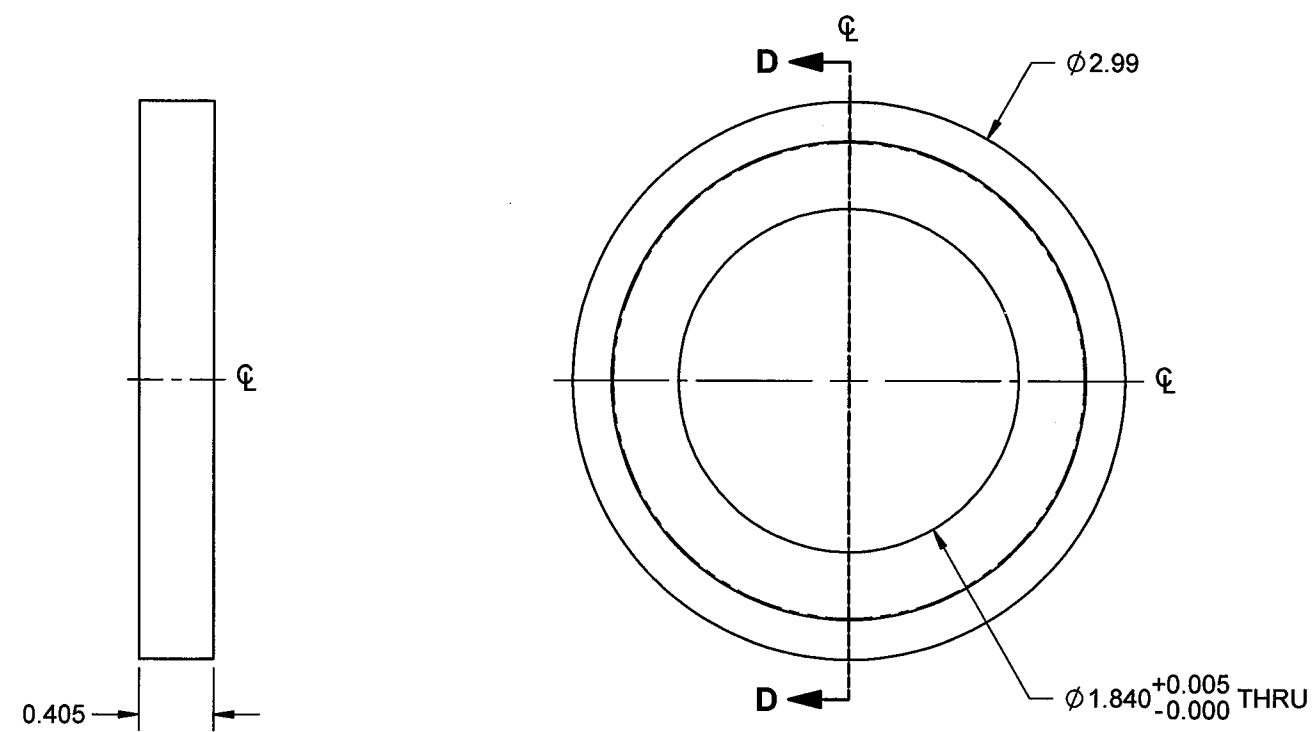
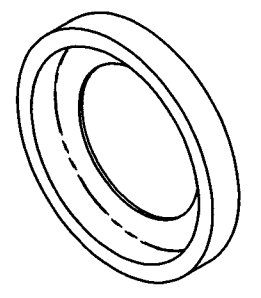
**RELEASED**

2020 SEP 04

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	KPT	TOOL PART #	REV. C
MFG. APPR.	FK	<b>RBE117-15004W6</b>	SHEET 8 OF 14
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE <b>9/1/2020</b>		<b>PUSH OUT / PRESS IN TOOL</b>	NTS
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8 7 6 5 4 3 2 1



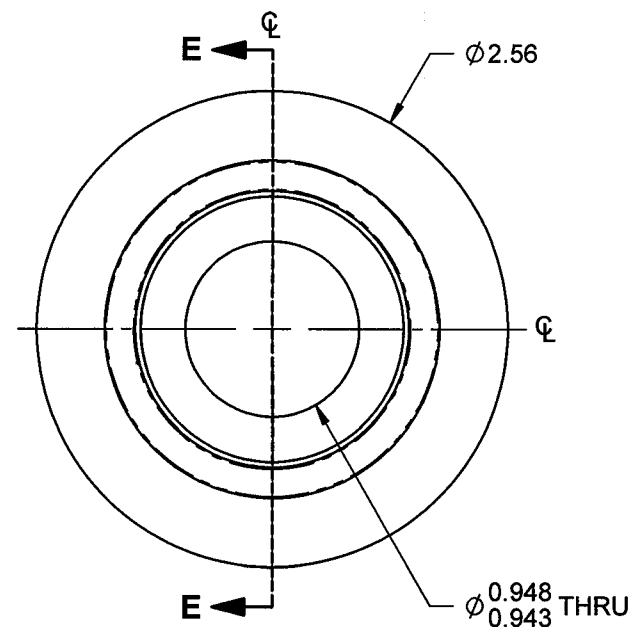
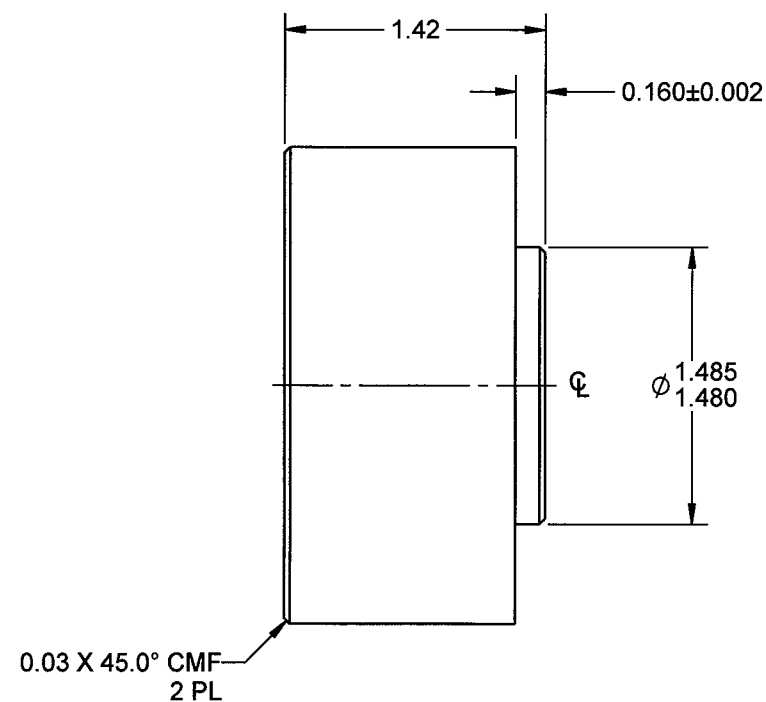
**RBE117-15004W6-15 SPACER RING**

8 9 10

- NOTES:
- 1) MATERIAL: O1 TOOL STEEL PER ASTM A681
  - 2) HEAT TREAT: 48-52 RC
  - 3) FINISH: ZINC PLATE PER ASTM B633 SC 2 TYPE 2 (BLACK CHROMATE CONVERSION COATING)
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) BREAK SHARP EDGES: 0.005 TO 0.010
  - 7) IDENTIFICATION: N/A
  - 8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG
  - 9) PART IS SYMMETRIC ABOUT CENTERLINES
  - 10) DIMENSIONAL LIMITS APPLY AFTER PLATING

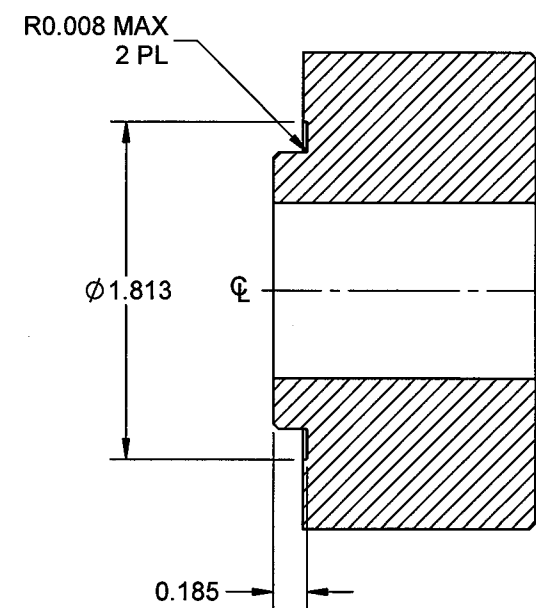
RELEASED  
2020 SEP 04

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	KPT	TOOL PART #	REV. C
MFG. APPR.	FK	<b>RBE117-15004W6</b>	SHEET 9 OF 14
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE <b>9/1/2020</b>		<b>PUSH OUT / PRESS IN TOOL</b>	NTS
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# **RBE117-15004W6-17 THRUST PIECE 2**

8 9 10



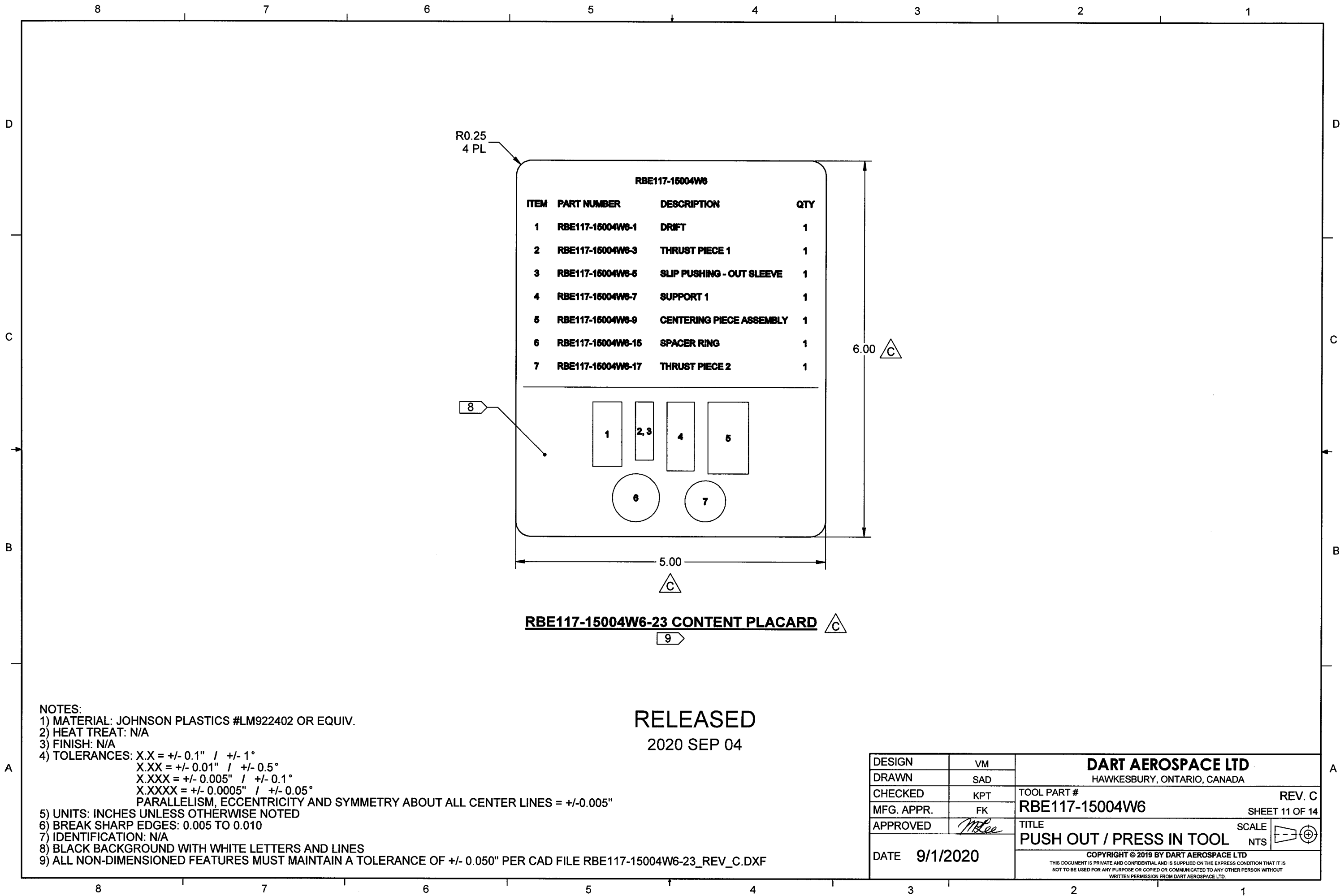
## **SECTION E-E**

### **NOTES:**

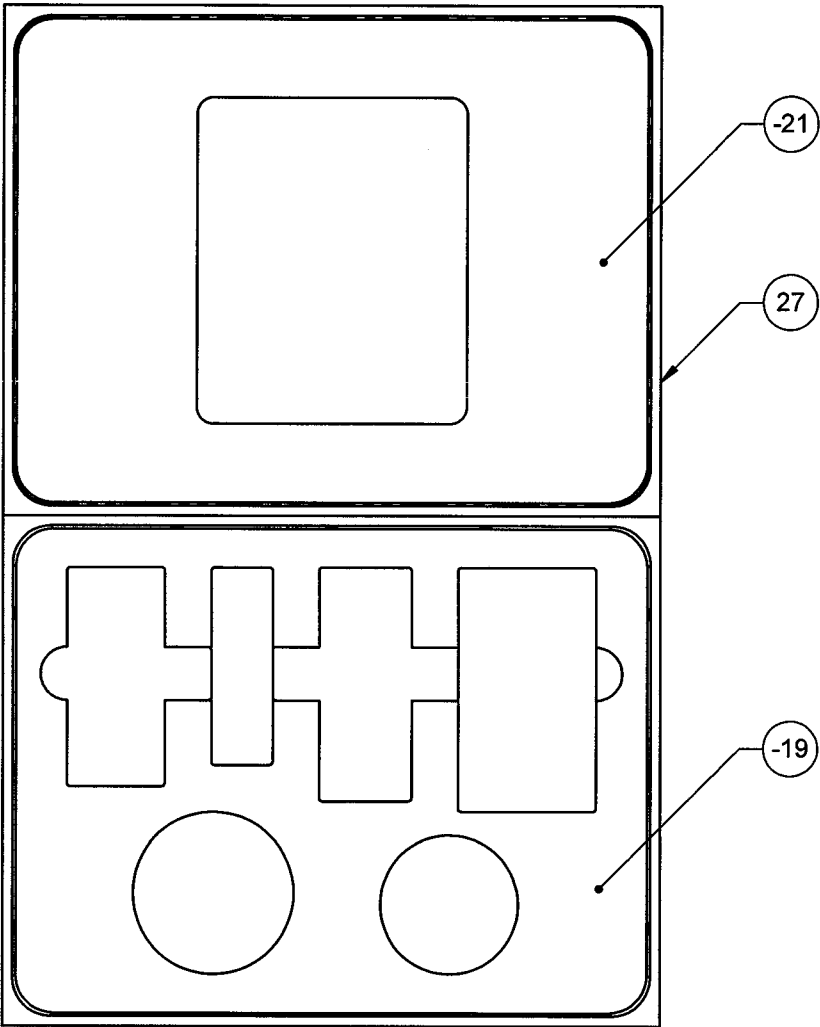
- 1) MATERIAL: O1 TOOL STEEL PER ASTM A681
- 2) HEAT TREAT: 48-52 RC
- 3) FINISH: ZINC PLATE PER ASTM B633 SC 2 TYPE 2 (BLACK CHROMATE CONVERSION COATING)
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010
- 7) IDENTIFICATION: N/A
- 8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG
- 9) PART IS SYMMETRIC ABOUT CENTERLINES
- 10) DIMENSIONAL LIMITS APPLY AFTER PLATING

**RELEASED**  
2020 SEP 04

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	KPT	TOOL PART #	REV. C
MFG. APPR.	FK	<b>RBE117-15004W6</b>	SHEET 10 OF 14
APPROVED	<i>MLee</i>	TITLE	SCALE
DATE <b>9/1/2020</b>		<b>PUSH OUT / PRESS IN TOOL</b>	NTS
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ITEM #	QTY	PART #	PART TITLE
-19	1	RBE117-15004W6-19	BOTTOM FOAM
-21	1	RBE117-15004W6-21	TOP FOAM
27	1	PELICAN #APP-1400-E	PELICAN CASE 1400

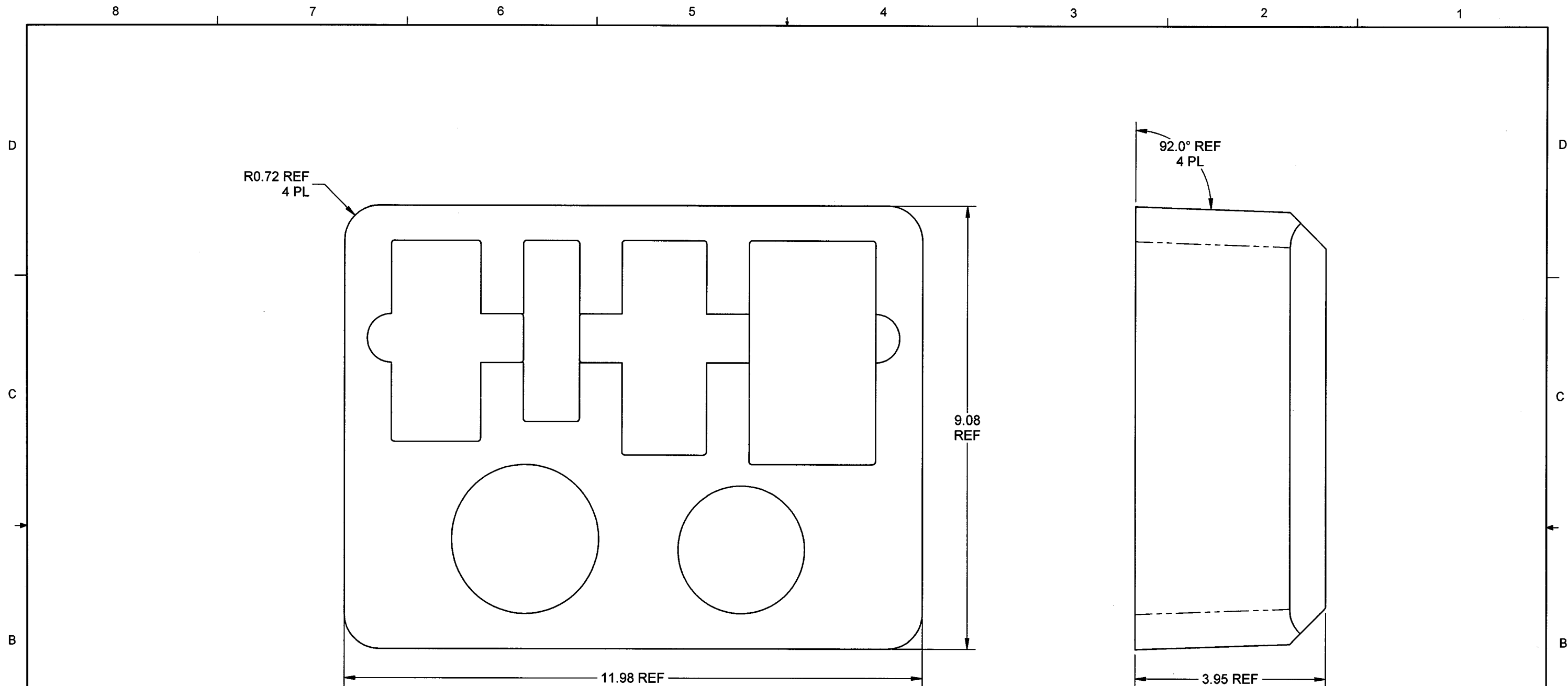


**RBE117-15004W6-24 PACKAGING ASSEMBLY**

RELEASED  
2020 SEP 04

NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) BREAK SHARP EDGES: N/A  
7) IDENTIFICATION: N/A

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	KPT	TOOL PART #	REV. C
MFG. APPR.	FK	<b>RBE117-15004W6</b>	SHEET 12 OF 14
APPROVED	<i>MLee</i>	TITLE	SCALE
DATE <b>9/1/2020</b>		<b>PUSH OUT / PRESS IN TOOL</b>	NTS
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**RBE117-15004W6-19 BOTTOM FOAM**

8

RELEASED  
2020 SEP 04

NOTES:

- 1) MATERIAL: BLACK ETHAFOAM 220 REF
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBE117-15004W6-19\_REV\_C.STEP

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	KPT	TOOL PART #	REV. C
MFG. APPR.	FK	<b>RBE117-15004W6</b>	SHEET 13 OF 14
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE <b>9/1/2020</b>		<b>PUSH OUT / PRESS IN TOOL</b>	NTS
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